

Date: Thursday, 11/8/2007 8:01:14 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE TRIM ANGLE
Job Number	: 35583		
Estimate Number	: 10228		
P.O. Number	: N/A	Part Number	: D2163
This Issue	: 11/8/2007 S.O. No. : N/A	Drawing Number	: D2163 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/6/2007 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	: N/A
Written By	: <u>07-11-08</u>	Due Date	: 12/20/2007 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est F 02.05.11 Clarify IPP NG		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M5052H32S050

5052-H32 .050 Sheet



3.8637



Comment: Qty.: 0.0729 sf(s)/Unit Total : 2.9148 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.050" thick  
(M5052H32S.050)Batch: 14050 1B 07-11-12

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2163

Dwg Rev: BProg Rev: B1B 07-11-12S3

2-Deburr if necessary

1B 07-11-12

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

1B 07-11-12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

07-11-13(S3)

Comment: SECOND CHECK

counted.

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per QSI 003 and Dwg D2163

07/12/03(S3)07/12/03(S3)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE TRIM ANGLE

Job Number: 35583

Part Number: D2163

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

5 07/12/04 (53)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/12/05 (53)

8.0 POWDER COATING

POWDER COATING



M100700



(53X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/12/05

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(53)

Comment: INSPECT POWDER COAT

BK 07-12-05

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 18

7/12/06 SP (53X)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(53)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/06

Job Completion



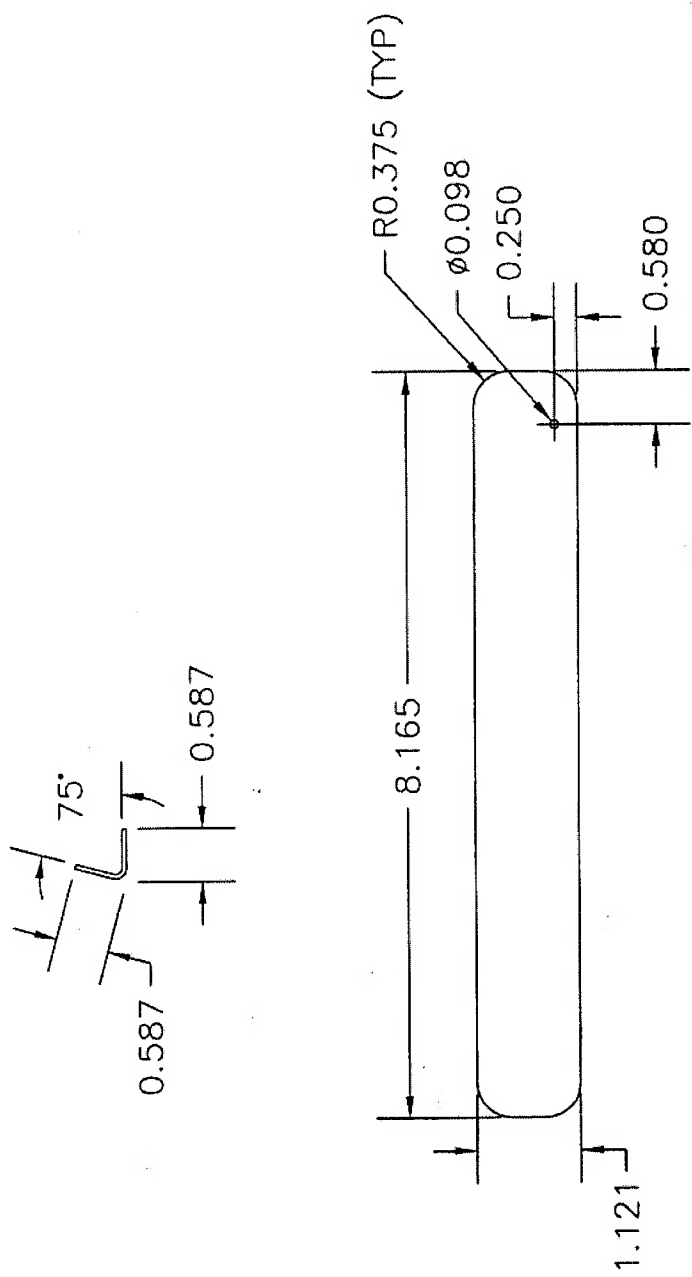
07-12-06





DESIGN <i>Q</i>	DRAWN BY <i>Bw</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JA</i>	DRAWING NO. D2163	REV. B SHEET 1 OF 1
DATE 97.10.30		TITLE TRIM ANGLE	SCALE 1:2
A	95.05.19	RE-DRAWN	
B	97.10.30	REMOVE BEND DATA	

RELEASED  
97.11.04 KE  
TSR A421



MATERIAL: 5052-H32 (QQ-A-250/8) 0.050 THICK  
FINISH: POWER COAT MATTE BLACK PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35583*